



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-796-035
Job Sheet 181781



Part No: D119-796-035

Job Qty: 1 ea

Part Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-on Landing Wearplates, Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/8/18

Job Tracking No:

Due Date: 10/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D119-796-035 REV B, IIN-D119-796 REV F IPP REV:A NEW ISSUE 15-05-13 JLM VERIFIED BY:DD
IPP REV:B 15.08.25 AS PER ECN15-580 DD VERF:JLM IPP REV:C 18.03.22 ADDED D5449-1 DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/11/18	10/11/18	0.00	0.00	Start Up Stores/Pkg-1		OCT 24 2018
100	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging1-1		OCT 24 2018
110	HandFinish	1 pcs	10/11/18	10/11/18	0.00	0.00	HandFinish4		Smf
120	QC	1 pcs	10/11/18	10/11/18	0.00	0.00	QC5		
125	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging1-1		
127	QC	1 pcs	10/11/18	10/11/18	0.00	0.00	QC4		
130	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging3-1		NOV 02 2018
140	QC21-FG	1 Ea	10/11/18	10/11/18	0.00	0.00	QC21		NOV 02 2018

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-035 chg 004/D119-646-243 paperwork
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11 ASSEMBLE WITH PROSEAL BATCH: 2-INSTALL
DECAL D2729-4
130 - Identify and pack for shipping as per PPP D119-796-035 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	8 Ea (8 ea)	90-Start up Operation	5024836
AN3C50A	Bolt	16 Ea (16 ea)	90-Start up Operation	5093750103 5095437 X3
AN4C6A	Bolt	24 Ea (24 ea)	90-Start up Operation	5076002X17 5092427
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	2 Ea (2 ea)	90-Start up Operation	5089688 1x 5095015 u
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5117022
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5117197
D2652	Bushing	48 Ea (48 ea)	90-Start up Operation	5116378
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	2104492
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	508981043 5116319X1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																								
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																													
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																													
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																													
Large Fab ☐	Composite ☐	Supplier ☐																																																														
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval _____																																																									
Description Work Order Deviation				Disposition																																																												
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td><td style="border: none;">Pressure/Forced ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td><td style="border: none;">Bending ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td><td style="border: none;">Centre Not Concentric ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td><td style="border: none;">Cracks ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td><td style="border: none;">Cuffs ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td><td style="border: none;">Crushing ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td><td style="border: none;">Heat Treat ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td><td style="border: none;">Wave/Twist in Tube ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td><td style="border: none;">Marks/Chatter ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td><td></td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td><td></td></tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power ☐</td></tr> <tr><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio, ☐</td></tr> <tr><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td></tr> <tr><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td></tr> <tr><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wro ☐</td></tr> <tr><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td></tr> <tr><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td></tr> <tr><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td></tr> <tr><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td></tr> <tr><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td></tr> </table>					Temperature/Cure ☐	Power ☐	Set-up ☐	Folio, ☐	BOM/Route ☐	Grain ☐	Broken/Damage/Defect ☐	Weld ☐	Inspection Incomplete/Unqualified ☐	Wro ☐	Contamination ☐	Out of Sequence ☐	Countersink ☐	Off-set ☐	Cut Too Short ☐	Mislabeled ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Drill Holes ☐	Misaligned/off center ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐																																																														
Design ☐	Operator ☐	Bending ☐																																																														
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐																																																														
Equip/Tooling ☐	Supplier ☐	Cracks ☐																																																														
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐																																																														
Material ☐	Use for Testing ☐	Cuffs ☐																																																														
Internal Transport ☐	Poor Information ☐	Crushing ☐																																																														
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																																														
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																																														
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																																														
Past Expiry Date ☐	Manufacturing Process ☐																																																															
Misidentified ☐	Past Due ☐																																																															
Temperature/Cure ☐	Power ☐																																																															
Set-up ☐	Folio, ☐																																																															
BOM/Route ☐	Grain ☐																																																															
Broken/Damage/Defect ☐	Weld ☐																																																															
Inspection Incomplete/Unqualified ☐	Wro ☐																																																															
Contamination ☐	Out of Sequence ☐																																																															
Countersink ☐	Off-set ☐																																																															
Cut Too Short ☐	Mislabeled ☐																																																															
Instructions Incomplete/Unclear ☐	Fit/Function ☐																																																															
Drill Holes ☐	Misaligned/off center ☐																																																															
OTHER : _____				 Part: D119-796-035 Job No: 181781 Serial No/Batch: S120963 Revision: B / F Inspector: _____ Exp Date: _____ Instructions: TC STC SH14-45 - Issue 1, FAA/STC SR0350. Wrong Dimensions tolerance ect issing Part involved Drawing Finish Misread Turning Sequence																																																												

D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	S079335
D3672-3	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	S027022
D3672-7	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	F157442X19 S120670X29
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	S101876
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	90-Start up Operation	S102701
D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	S103378
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	90-Start up Operation	S104446
D3886-041	Lug Assembly	4 Ea (4 ea)	90-Start up Operation	S105220
MS21043-3	Nut	24 Ea (24 ea)	90-Start up Operation	S083543
MS21043-4	Nut	26 Ea (26 ea)	90-Start up Operation	S092684
MS21043-5	Nut	8 Ea (8 ea)	90-Start up Operation	S083544
MS21250-05048	Bolt (Use Ms21250-05-048)	8 Ea (8 ea)	90-Start up Operation	S09378015 S10999413
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	S104354
NAS1149C0432R	Washer	48 Ea (48 ea)	90-Start up Operation	S087052
NAS1149C0532R	Washer	16 Ea (16 ea)	90-Start up Operation	S089242
D5449-1	Float Saddle Washer	4 Ea (4 ea)	90-Start up Operation	S103309X1 S108273X3
MS21920-28	Clamp	2 Ea (2 ea)	125-Packaging	S102730

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C46A	8	185	0
	AN3C50A	16	239	0
	AN4C6A	24	341	0
	D119-646-243	2	6	0
	D119-796-151	1	2	0
	D119-796-251	1	2	0
	D2652	48	681	0
	D3407-041	2	5	0
	D3417-5	4	51	0
	D3456-1	2	281	0
	D3672-3	48	931	0
	D3672-7	48	427	0
	D3883-1	2	1	0
	D3883-2	2	1	0
	D3884-1	2	7	0
	D3884-2	2	10	0
	D3886-041	4	28	0
	D5449-1	4	1	0
	MS21043-3	24	1,234	0
	MS21043-4	26	1,474	0
	MS21043-5	8	238	0
	MS21250-05048	8	32	0
	NAS1149C0332R	24	4,869	0
	NAS1149C0432R	48	1,141	0
	NAS1149C0532R	16	349	0
	MS21920-28	2	43	0
125-Packaging				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					